W	ork	Ord	ler II	53	965
* *	UI N	$\mathbf{v}_{\mathbf{I}}$, ,,	700

Page 1

November 24, 2009 10:30:18 AM D2253-1 Item ID: Accept Setup Start **Revision ID:** Stop Item Name: Lug Start Qty: 6.00 **Cust Item ID: Start Date:** 24/11/2009 Required Date: 02/12/2009 Req'd Qty: 6.00 **Customer:** Reference: Run Start Date 04/1-24 Tooling: Approvals: Date: Stop Date: QC: SPC (Y/N): Date: Operation Reject Sequence ID/ Set Up/ Draw Plan Draw Accept Number Work Center ID Description Qty Qty **Run Hours** Number Rev. Code **Draw Nbr Revision Nbr** D2253 Rev C 0.00 100 18 G-11-24

FLOW CNC Waterjet

Memo

Cut as per dwg D2253 Prog Rev: Dwg Rev:

Deburr as required

110

Waterjet

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

Memo

0.00

139-11-24

Quality Control

Reject Insp.

Stamp

Dart Aerospace L	Ltd
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	•								खर				
W/O:			WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CHAN	IGE	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
			5.5				e 2, a						
	1,												
		PAR #:	Fault Category: NC			NCR: Yes No DQA: Date:							
	R	esolution:	Disposition	:	QA: N/C	Closed: _		Date: _	<u>. </u>				
NCR:			WORK ORDE	ER NON-CONFORM	MANCE (NO	R)							
DATE	STEP	Description of NC	Corrective Action Section B			Verification Approve			l Approval				
		Section A	Initial Chief Eng	Action Description Chief Eng	Dai		ction C	Chief Eng	QC Inspector				
					`								
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NOTE: Date & initial all entries

Item ID:

D2253-1

Accept

Setup Start

Stop



Revision ID:

Item Name: Lug

Start Qty: 6.00 24/11/2009

Req'd Qty: 6.00

Cust Item ID: Customer:

Reference:

Start Date:

Approvals:

Process Plan:

Date:

Date: _____

Tooling:

Date:

Run

Start

Required Date: 02/12/2009

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

120

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/ **Run Hours**

Draw Number Draw Plan Rev. Code Accept Qty

Reject **Qty**

Reject Insp. Number Stamp

27002/11/25

140

Packaging

Packaging

Identify as per dwg & Stock Location: IFR OM 0.00

Memo

0.00

/(5/4/20 kg)

150

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

1 09/11/25 Al 09/11-25

Dart /	Aero	space	Ltd
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	•									**			
W/O:		WORK ORDER CHANGES											
DATE	STEP	PR	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
			и .				·		· · · · · · · · · · · · · · · · · · ·				
•			Fault Categ	jory:	NCR: Yes No DQA: Date:								
		solution:											
NCR:			WORK ORDE	R NON-CONFORM	MANCE	(NCF	R)						
DATE	STEP	Description of NC	Corrective Action Section				Verific	ation	Approval	Approval			
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	n	Sign 8 Date	Section		Chief Eng	QC Inspector			

NOTE: Date & initial all entries

Picklist Print

November 24, 2009 10:34:07 AM

Work Order ID: 53965

Parent Item: D2253-1RevC

Parent Item Name: Lug

Comments:

IPP Rev:D Now on Waterjet 06-06-16 JLM

Start Date: 24/11/2009

Required Date: 02/12/2009

Page 1

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	M.fg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	126.2400).6		<u>. </u>
										1R9-11-24		

304/316 0.125 Sheet

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
MAT	126.24	
112663	126.24	



Dart Aerospace Ltd	_td	ace	OS	Aer	art	D
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W/O:			WC	RK ORDER CHAI	NGES					د ع		
DATE	STEP	PR	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
			- W	* .				,		٠.		
							ν.					
Part No: PAR #:							NCR: Yes No DQA: Date:					
	R	esolution:	Disposition	Disposition: QA			sed:		Date:	7 u 		
NCR:			WORK ORDI	R NON-CONFOR	MANCE	(NCR)		2			
DATE	STEP	Description of NC	NC Corrective Action Section B			verification			Approval	Approval		
	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	on	Sign & Date	Section C	on C	Chief Eng	QC Inspector		
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	1											
								-				

NOTE: Date & initial all entries

ART AERO	SPACE LTD				Work Order:	53965 D2253-1	
escription:	Luc				Part Number:		
nspection Dwg	1:D2-353-1 Rev:	<u></u>				Page 1 of 1	
	FIRST	ARTICLE IN	SPECTION	ON CHE	CKLIST		
	X	First Artic	:le	Proto	type		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments	
,500	4 .010 - 080	507	70	A**			
2.93	1/- ,010	2.928	8				
5.700	L 010	5,750	×				
175	4- 010	,117	9	 			
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			Prototype Approval:	N/A
Measured by:	B.	Audited by:		
Date:	9-11-74	Date:	Date:	18/7

		Revised by	Approved
Rev	Date	Change KJ/JLM	
Α		New Issue	· · · · · · · · · · · · · · · · · · ·





	PREPARED	DART AERO ACCESSORIES INC
	C. Meeker	VICTORIA INTERNATIONAL AIRPORT, CANADA
	CHECKED	REV. C
	BW	D2253 SHEET 1 OF 1
	DATE	TITLE SCALE
	Jun. 14, 1994	LUG ASSEMBLY 1:1
	C 95.12.22	REMOVED BUSHING

RELEASED 199.10.12 KE

D2253-1 M/F 1/8 THICK 304/316 SS

SHOPELLI RI JERO D ENC YOU TO G UNCONTROLLED CONS SUBJECT TO AMENDA and a WITHOUT NOT C WORK OKDER NO 53945

